

FIG. 1

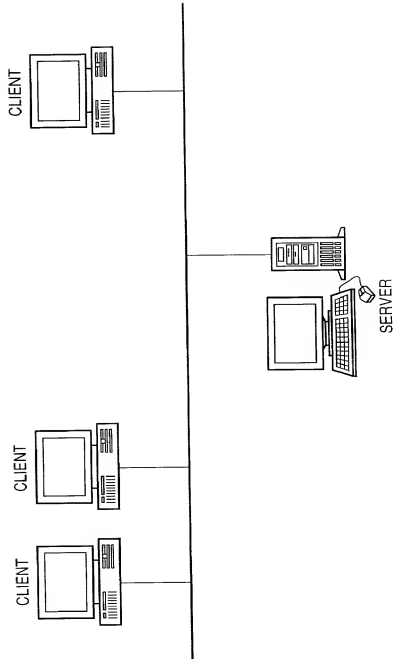


FIG. 2

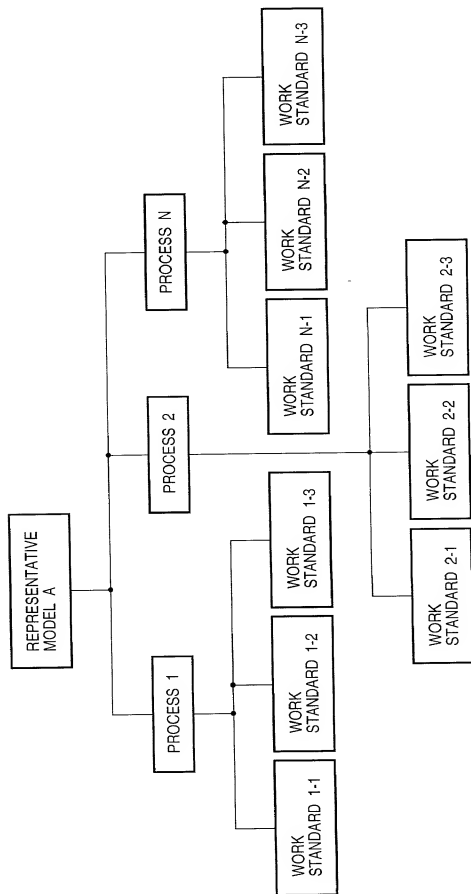


FIG. 3

| WORK STANDARD 01 CREATION | | | | | | | | | | 302 | | | | | | | | | | | | | | | | | | | | | | | | |
|---|----------------------|------------|----------------------|-----------|----------------|-----|--|--|--|-----------------|----------------------|----------|----------------------|-----------|-----------|-----|---------|------------|--|--|--|--|--|--|--|--|----------------|-----|--|-----|--|-----|-----|-----|
| APPLIED | | | | | | | | | | 301 | | | | | | | | | | | | | | | | | | | | | | | | |
| <table border="1"> <thead> <tr> <th>PART NUMBER</th> <th>PART NAME</th> <th>QUANTITY</th> <th>PART NUMBER</th> <th>PART NAME</th> <th>QUANTITY</th> </tr> </thead> <tbody> <tr> <td>303</td> <td>304</td> <td>305</td> <td></td> <td></td> <td></td> </tr> <tr> <td colspan="6">TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL</td> </tr> <tr> <td></td> <td></td> <td>306</td> <td></td> <td>307</td> <td>308</td> </tr> </tbody> </table> | | | | | | | | | | PART NUMBER | PART NAME | QUANTITY | PART NUMBER | PART NAME | QUANTITY | 303 | 304 | 305 | | | | TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL | | | | | | | | 306 | | 307 | 308 | 300 |
| PART NUMBER | PART NAME | QUANTITY | PART NUMBER | PART NAME | QUANTITY | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 303 | 304 | 305 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | 306 | | 307 | 308 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <table border="1"> <thead> <tr> <th>No.</th> <th>WORK PROCEDURE</th> <th>No.</th> <th>NOTE / STANDARD ETC.</th> </tr> </thead> <tbody> <tr> <td></td> <td>310</td> <td></td> <td></td> </tr> </tbody> </table> | | | | | | | | | | No. | WORK PROCEDURE | No. | NOTE / STANDARD ETC. | | 310 | | | 309 | | | | | | | | | | | | | | | | |
| No. | WORK PROCEDURE | No. | NOTE / STANDARD ETC. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 310 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| <table border="1"> <thead> <tr> <th>REVISION NUMBER</th> <th>CONTENTS OF REVISION</th> <th>DATE</th> <th>PERSON IN CHARGE</th> <th>APPROVE</th> <th>WORK NAME</th> </tr> </thead> <tbody> <tr> <td>01</td> <td>CREATED</td> <td>1997/09/25</td> <td></td> <td></td> <td></td> </tr> <tr> <td colspan="5"></td> <td>MANAGEMENT NO.</td> </tr> </tbody> </table> | | | | | | | | | | REVISION NUMBER | CONTENTS OF REVISION | DATE | PERSON IN CHARGE | APPROVE | WORK NAME | 01 | CREATED | 1997/09/25 | | | | | | | | | MANAGEMENT NO. | 313 | | | | | | |
| REVISION NUMBER | CONTENTS OF REVISION | DATE | PERSON IN CHARGE | APPROVE | WORK NAME | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 01 | CREATED | 1997/09/25 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | | MANAGEMENT NO. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | | | 312 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | | | 311 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

FIG. 4

STRUCTURE OF MASTER FILE

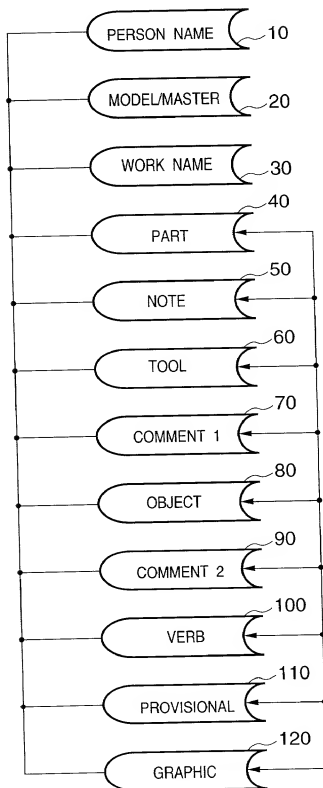


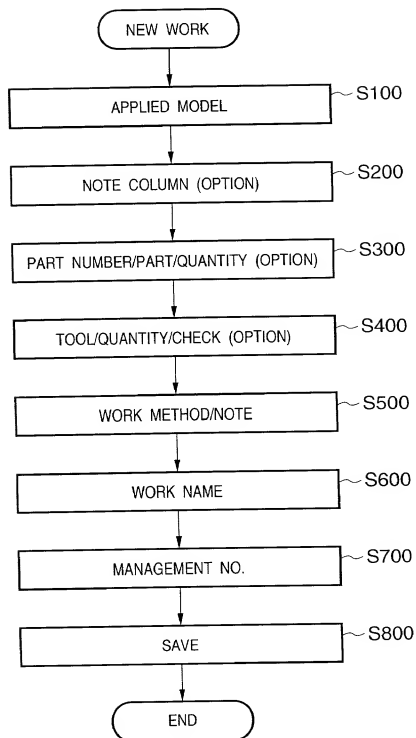
FIG. 5

FIG. 6

| SELECTION OF APPLIED MODEL |
|----------------------------|
| LIST OF APPLIED MODELS |
| BJC-4200 SYSTEM |
| BJC-420J |
| BJC-420J (BLACK) |
| BJC-4300 |
| BJC-430J |
| BJC-4200LX |
| A250 II Q |
| BJC-4200 |
| OK |
| CANCEL |

FIG. 7

| | | | | | | |
|---------------------------|-----------|-----------------------------------|-------------|-----------|----------|---|
| WORK STANDARD 01 CREATION | | | | | [-] [X] | |
| APPLIED | | BJC-420J BJC-420J(BLACK) BJC-430J | | | | |
| | | | | | | |
| PART NUMBER | PART NAME | QUANTITY | PART NUMBER | PART NAME | QUANTITY | ▲ |
| | | | | | | |

302

FIG. 8

| PART NUMBER | PART NAME | QUANTITY | PART NUMBER |
|------------------|----------------|----------|-------------|
| PART | | | |
| 000 - 0000 - 001 | PART 001 | ▲ | ----- |
| 000 - 0000 - 002 | PART 002 | | ----- |
| 000 - 0000 - 003 | PART 003 | | ----- |
| 001 - 0000 - 001 | PART 101 | ▼ | ----- |
| 001 - 0000 - 002 | PART 102 | | ----- |
| 111 - 1111 - 001 | PART 001 | | ----- |
| A01 - 1234 - 001 | TEST PART 0001 | | ----- |

09753941-010301

FIG. 9

• WORK NAME

GE ____

• CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 10

09753944.010301

- WORK NAME

現像(GENZOU) __
- CANDIDATES

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING
RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING
RAIL RETURN SPRING(AFTER))

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER
IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN
DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT) ~を

1103 (COMMENT 2)

1104 (VERB) ~する

00 ※ 1105a

01 1105b

1105

NOTE, STANDARD/REQUIRED QUALITY :

1106

1107

OK CANCEL 1108

FIG. 12

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1201

1202

00 ※ 1105b

01

FIG. 13

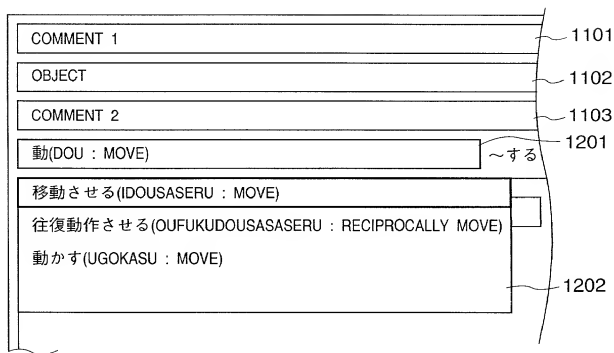


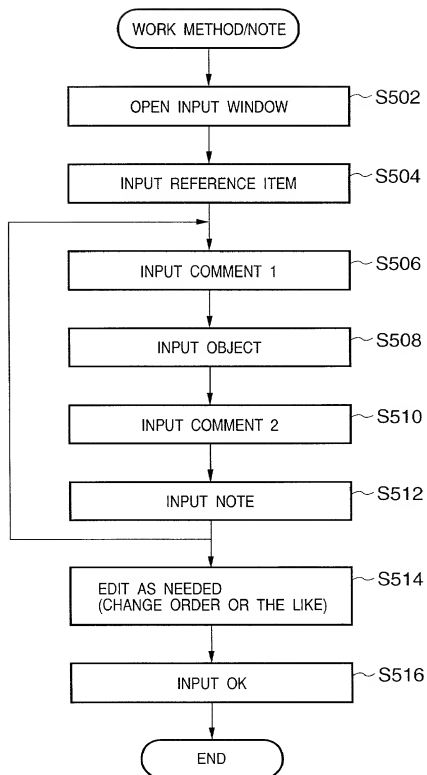
FIG. 14

FIG. 15

| | | |
|----|--|--|
| 00 | ※ | |
| 01 | DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy | |
| 02 | WIND AV CORD | |
| 03 | CONFIRM 100V SYSTEM | |
| 04 | SET CRG HOLDER | |
| | | |
| | | |

FIG. 16

| | |
|--|------|
| NOTE, STANDARD / REQUIRED QUALITY | |
| NOTE | 1601 |
| <p>SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu</p> <p>DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE</p> <p>DON'T HOOK PAPER GUIDE u ON SHEET HOLDER</p> <p>BEWARE OF IMITATIONS</p> <p>BEWARE OF IMITATIONS(Color Style Write</p> | |
| | 1602 |

FIG. 17

| NOTE, STANDARD / REQUIRED QUALITY | |
|-----------------------------------|------|
| 1 | NOTE |

1107

FIG. 18

| CONFIRM | |
|-----------------------------------|----------------|
| 00 ※ | |
| 01 CONFIRM 100V SYSTEM | |
| 02 WIND AV CORD | CUT(I) |
| 03 SET CRG HOLDER | COPY(C) |
| 04 | PASTE(P) |
| | ADD(A) |
| | DELETE(D) |
| | UNDO |
| | REVISE(CHANGE) |
| | REVISE(DELETE) |
| NOTE, STANDARD / REQUIRED QUALITY | |

1802

FIG. 19

| | |
|------------------------|-----|
| CONFIRM | ~する |
| 00 ※ | |
| 01 WIND AV CORD | |
| 02 CONFIRM 100V SYSTEM | |
| 03 SET CRG HOLDER | |
| 04 | |

NOTE, STANDARD / REQUIRED QUALITY

FIG. 20

| CONFIRM | |
|-----------------------------------|---|
| 00 ※ | |
| 01 WIND AV CORD | |
| 02 SET CRG HOLDER | |
| 03 | <div>CUT(I) COPY(C) PASTE(P)</div> |
| | <div>ADD(A) DELETE(D)</div> |
| NOTE, STANDARD / REQUIRED QUALITY | <div>UNDO REVISE(CHANGE) REVISE(DELETE)</div> |

1802

FIG. 21

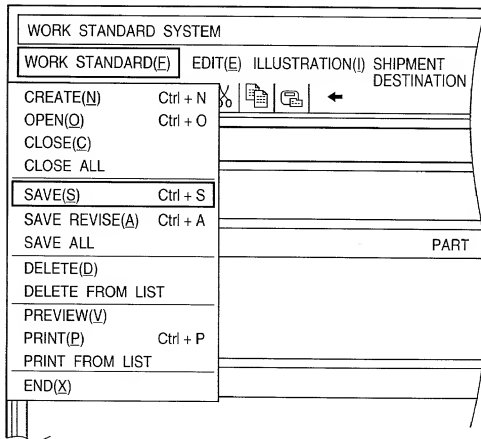
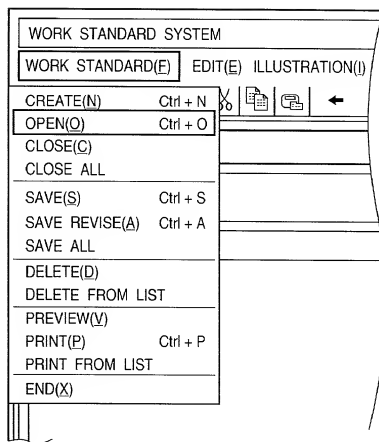


FIG. 22



23/97

FIG. 23

| WORK STANDARD SYSTEM | | | |
|---|-----------------|------------|----------------------|
| <input checked="" type="radio"/> LATEST REVISION NUMBER <input type="radio"/> ALL | | | |
| MANAGEMENT NO. | REVISION NUMBER | WORK NAME | DATE OF REGISTRATION |
| SO-04-01(4)-E | 01 | ASFu取付 | 1997/09/13 |
| SO-01-01(3)-E | 01 | ベ-ス・トレ-u取付 | 1997/09/01 |
| SO-01-03-E | 01 | ベ-ス・トレ-u取付 | 1997/09/01 |
| SO-01-04-E | 01 | ベ-ス・トレ-u取付 | 1997/09/01 |
| SO-06-01-E | 01 | 線処理 | 1997/09/01 |
| SO-06-02-E | 01 | 線処理 | 1997/09/01 |
| SO-06-03-E | 01 | 線処理 | 1997/09/01 |
| SO-07-01(2)-E | 01 | レールグリス塗布 | 1997/09/01 |
| SO-08-01-E | 01 | レール取付 | 1997/09/01 |

2301

FIG. 24





| SYSTEM | | | |
|---|---|-----------------|---|
| EDIT(E) | | ILLUSTRATION(I) | SHIPMENT DESTINATION(S) |
|  |  | VIEW(V) |   |
| | | EDIT(E) | |
| 01 CREATE | | PowerPoint | |
| | | ✓ Canvas | |

FIG. 25

| | | | |
|---------------------------|----------------|----------------------|-----------|
| WORK STANDARD 01 CREATION | | 302 | |
| APPLIED | | | |
| PART NUMBER | PART NAME | | |
| 303 | | | |
| TOOL / TREATMENT DEVICE | | | |
| | | | |
| | | | |
| No. | WORK PROCEDURE | | |
| | 2501 | | |
| FILE NAME : | | 2502 | 2503 2504 |
| UPDATE | | CLOSE | |
| CLEAR | | 2500 | |
| REVISION NUMBER | | CONTENTS OF REVISION | |
| 01 | DATE | PERSON IN CHARGE | APPROVE |
| | 1997/09/25 | | |
| CREATED | | WORK NAME | |
| | | | |
| | | MANAGEMENT NO. | |
| | | | |

FIG. 26

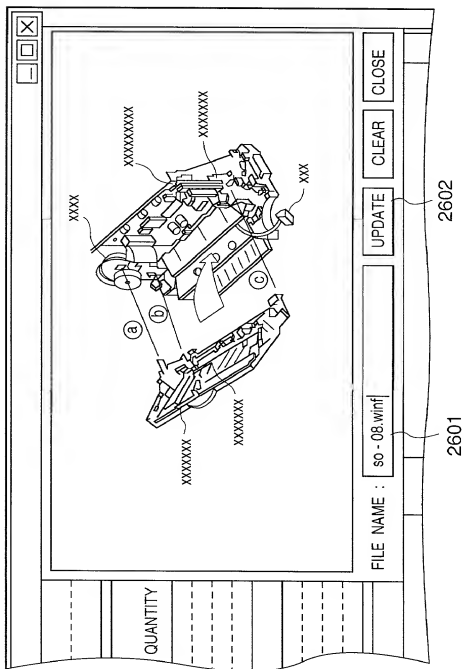


FIG. 27

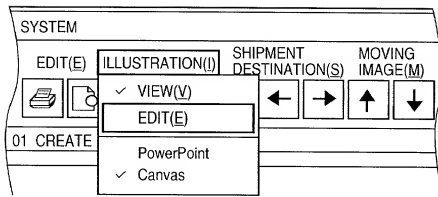


FIG. 28

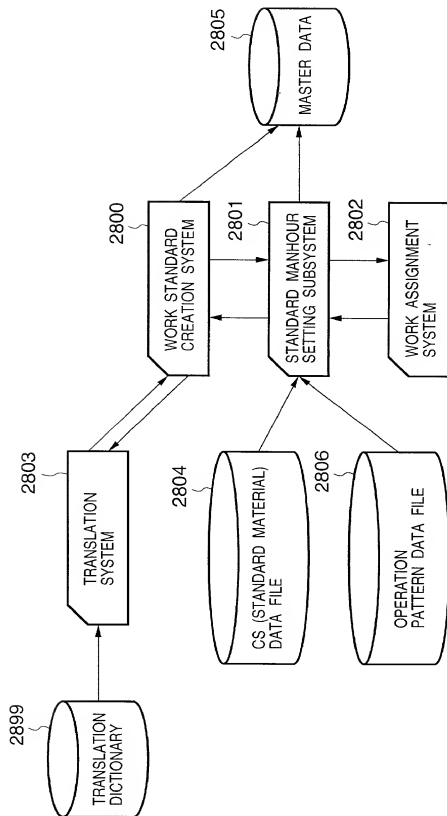


FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA

☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

TRANSLATION OF WORK STANDARD

3001 3002 3003 3004

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL
☒ UNIT
☐ ASSEMBLY

DISPLAY DATA
☒ ALL
☐ UNTRANSLATED
☐ UNCHECKED

DISPLAY LANGUAGE
☐ JAPANESE
☒ ENGLISH

3000

| MANAGEMENT NO. | REVISION NUMBER | WORK NAME | AUTOMATIC TRANSLATION | CHECK |
|----------------|-----------------|-------------|-----------------------|-------|
| PT - 010 - 010 | 01 | クリーナU取付 | X | X |
| PT - 010 - 020 | 01 | クリーナU取付 | X | X |
| PT - 010 - 030 | 01 | クリーナU取付 | X | X |
| PT - 070 - 030 | 01 | 切換アームAssy組立 | X | X |
| PT - 080 - 010 | 01 | 伝達ローラU取付 | X | X |
| PT - 090 - 010 | 01 | 伝達ローラU取付 | X | X |
| PT - 100 - 010 | 01 | 紙押え取付 | X | X |

SELECT ALL
 CANCEL SELECT
 VIEW
 TRANSLATE
 TRANSLATE ALL
 CLOSE

3006 3007 3008 3005

FIG. 31

| TRANSLATION OF WORK STANDARD (PROTOTYPE) | | | | | | | | | |
|--|--|------|----------|-----------------|---------|-------------------------|--|--|--|
| WORK STANDARD(E) ILLUSTRATION(I) VOICE(S) WINDOW(W) | | | | | | | | | |
| WORK STANDARD PN-030-020 01 New created by (PX2056) A252 PUMP UNIT | | | | | | | | | |
| Model | QG5-1319 | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| Part No. | Part Name | Qty | Part No. | Part Name | Qty | PN | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| Total | | | | | Qty | PN | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| No. | Procedure | | | | No. | Precaution / Conditions | | | |
| 01 | The blade lever spring hooks to ① of the blade lever. | | | | | | | | |
| 02 | Side the blade lever in the direction of arrow ② and check there is no catch and nor the return by the spring force. | | | | 02 - 01 | No Table Data 1 | | | |
| 03 | Check press-fitting the blade lever shaft leading edge to the braid folder leading edge. | | | | 03 - 01 | No Table Data 1 | | | |
| Details Is of Revision | | Data | By | Procedure | | | | | |
| 01 | New Created by (PX2056) | | OK | No Table Data 1 | | | | | |
| | | | | Page No. | | | | | |
| | | | | PN-030-020 | | | | | |

FIG. 32

WORK PROCEDURE

VOICE(W)

JAPANESE

WORK PROCEDURE

ブレード・レバー・ハネをブレード・レバーの ① 部に引っ掛ける

01 ブレード・レバー・ハネをブレード・レバーの ① 部に引っ掛ける

02 ブレード・レバーを矢印 ② 方向にスライドさせ引っ掛かり無くハネカで戻すことを確認する

03 ブレード・レバー軸先端がブレード・レバー先端まで圧入されていることを確認する

ENGLISH

Procedure

The blade lever spring hooks to ① of the blade lever.

01 The blade lever spring hooks to ① of the blade lever.

02 Slide the blade lever in the direction of arrow ② and there is no catch and n....

03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....

TRANSLATE OK CANCEL

FIG. 33

| | | | | | |
|--|--|----------|--|---|--|
| TRANSLATION OF WORK STANDARD (PROTOTYPE) | | | | <input type="button" value="-"/> <input type="button" value="X"/> | |
| WORK STANDARD(E) ILLUSTRATION(I) | | VOICE(S) | | DOW(W) | |
| WORK STANDARD PN-030-020 01 New | | PLAY(P) | | X2056) A252 PLATEN UNIT | |
| | | NEW(N) | | | |
| Model QG5-1317 | | DRIVE(D) | | | |
| | | | | | |
| | | | | | |

FIG. 34

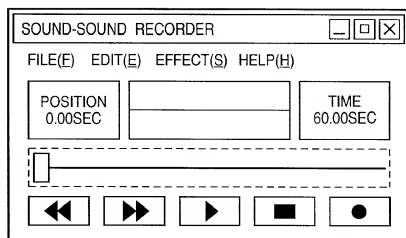


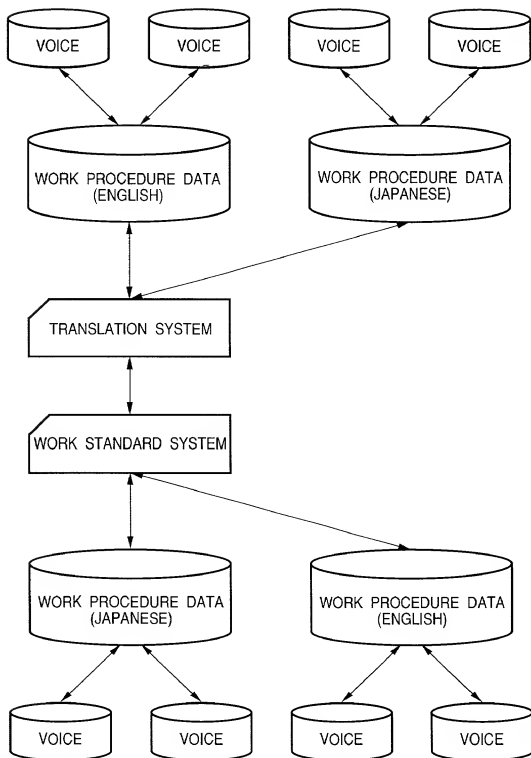
FIG. 35

FIG. 36

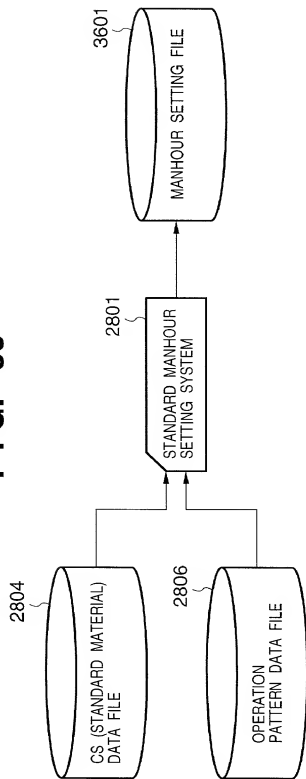


FIG. 37

| No. | ELEMENT WORK NAME | FREQUENCY | MAN-HOUR | CS | SET CONDITION |
|-----|-------------------|-----------|----------|----|---------------|
| | | | | | |
| | | | | | |
| | | | | | |

FIG. 38

STANDARD MATERIAL DATA

| COMMENT 1 | OBJECT | COMMENT 2 | VERB | SET CONDITION DATA |
|-----------|--------|-----------|------|--------------------|
| | | | | |
| | | | | |
| | | | | |

FIG. 39

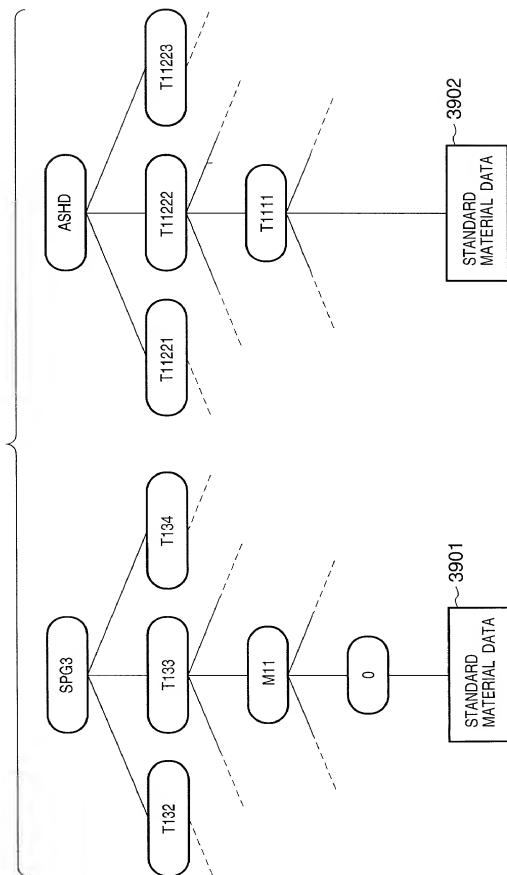
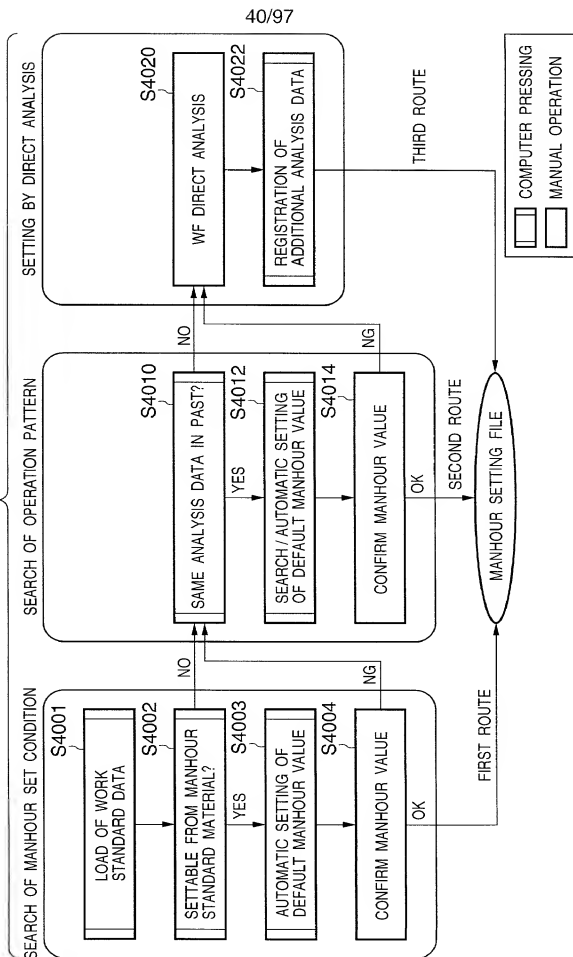


FIG. 40



3601

[illegible]

DATA LOAD

| No. | COMMENT 1 | OBJECT | COMMENT 2 | VERB |
|-----|-----------|--------|-----------|--------|
| 1 | | 負荷ハネを | 負荷ハネ取付治具に | 組込む |
| 2 | 治具の | SWを | | ONする |
| 3 | | 分離ロー軸を | 負荷ハネ取付治具に | 組込む |
| 4 | 治具の | SWを | | OFFにする |
| 5 | | 分離ロー軸を | 治具より | 外す |

SEARCH KEYWORD(KW)

| No. | COMMENT 1 | OBJECT | COMMENT 2 | VERB | MANHOUR STANDARD MATERIAL | TIME VALUE |
|-----|-----------|--------|-----------|--------|------------------------------|---------------|
| 1 | * | *ハネを | *に | 組込む | SPG3 T133 / M11 / 0 | 41RU |
| 2 | * | *を | *に | 組込む | ASHED T11222 / T1111 | 37RU |
| 3 | * | *を | *より | 外す | PUMQ T2111 / T111111 | 16RU |
| 4 | * | *Eリングを | * | 組込む | RIN2 T11211 / SO | 76RU |
| 5 | * | *コネクタを | * | 差し込む | CONN T11211 / SO | 41RU |
| 6 | * | * | * | 増し締めする | SCR6 M211 / 1 | 23RU |

030310141

| No. | ELEMENT WORK NAME | FREQUENCY | MANHOUR | CS | SET CONDITION |
|-----|--|-----------|---------|----|--------------------|
| 1 | 負荷バネを負荷バネ取付治具に組込む (SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING) | 1 | 1 | 61 | SPG3 T133/M11 /0 |
| 2 | 治具のSWをONにする (TURN ON SW OF TREATMENT DEVICE) | 1 | 1 | 8 | /GET:-50E/M:-10E |
| 3 | 分離ロー軸を負荷バネ取付治具に取り込む (SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING) | 1 | 1 | 37 | ASHD T11222/T1111 |
| 4 | 治具のSWをOFFにする (TURN OFF SW OF TREATMENT DEVICE) | 1 | 1 | 8 | /GET:-50E/M:-10E |
| 5 | 分離ロー軸を治具より外す (DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE) | 1 | 1 | 16 | PUMB T2111/T111111 |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

MATCH

| No. | COMMENT 1 | OBJECT | COMMENT 2 | VERB | VERB PATTERN | TIME VALUE |
|-----|-----------|-----------|-----------|-------|---------------------|------------|
| 1 | 治具の | SWを | | ONする | /GET:-50E/M:-10E | 8RU |
| 2 | 治具の | SWを | | OFFする | /GET:-50E/M:-10E | 8RU |
| 3 | | 読取操作部uを | | 閉める | /GET:-50E/M:-50E | 10RU |
| 4 | | CRGT'アを | | 閉める | /GET:-50E/M:-50E | 10RU |
| 5 | | 読取操作部uを | | 閉める | /GET:-50E/M:-50E | 10RU |
| 6 | | 電源コト'を | | 抜く | /GET:-50EGr2/M:-10E | 16RU |
| 7 | | 測定用電源コト'を | | 抜く | /GET:-50EGr2/M:-10E | 16RU |

[illegible]

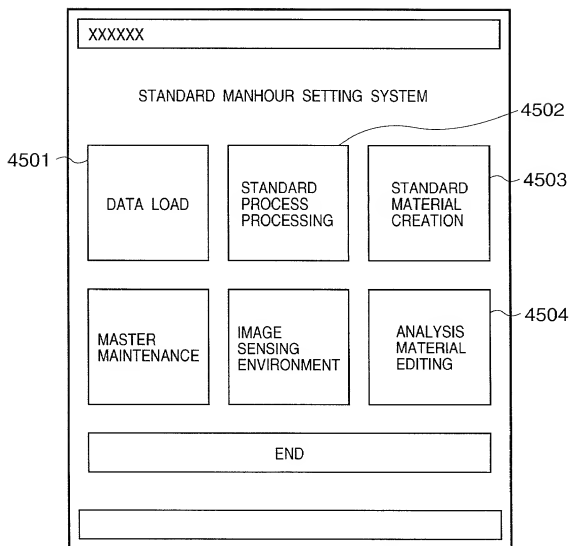
FIG. 45

FIG. 46

4609 4610 4612

XXXXXXX

☒ ALL ☐ DESIGNATE : 1

PRODUCT NUMBER :

NAME :

OK

4601

| PRODUCT NUMBER | WORK STANDARD | PRODUCT SYMBOL | NAME | PREVIOUS LOAD DATE |
|----------------|---------------|----------------|-------------|--------------------|
| 0 - CLOCK | XXXX | XX | XXXX | XXX |
| XXXXXX | | BL - OLD | SET IN 1996 | |
| xyz - test | | | | |
| test - 01 | | | | |
| test - AMI | | | | |

SELECT

CANCEL

4602 4603 4604 4605 4611

FIG. 48

LOAD OF DATA

COMPONENT DESIGNATION

☐ ALL

☒ DESIGNATE COMPONENT

CH

AUTOMATIC MANHOUR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

EXECUTE

CANCEL

4800

4801

4802

4803

4804

4805

4806

FIG. 49

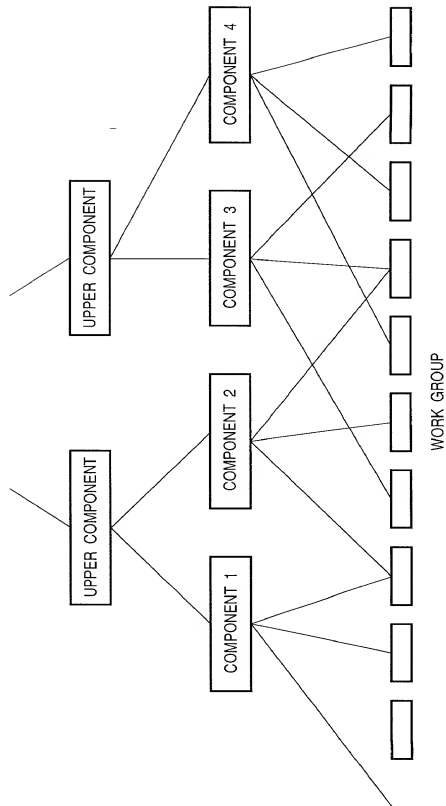


FIG. 50

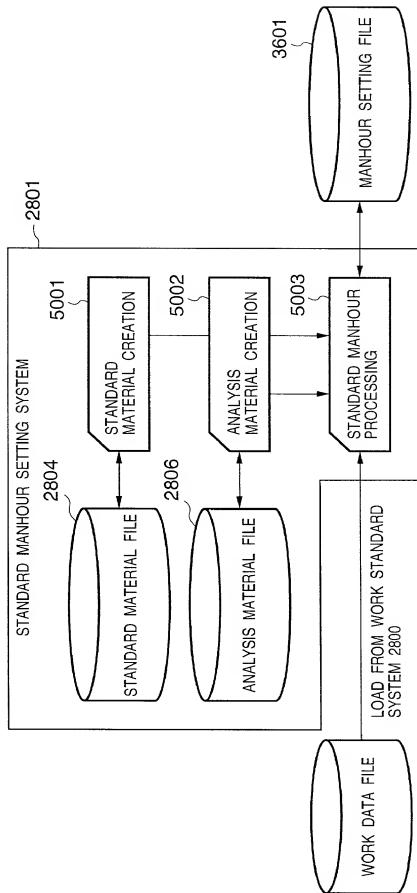


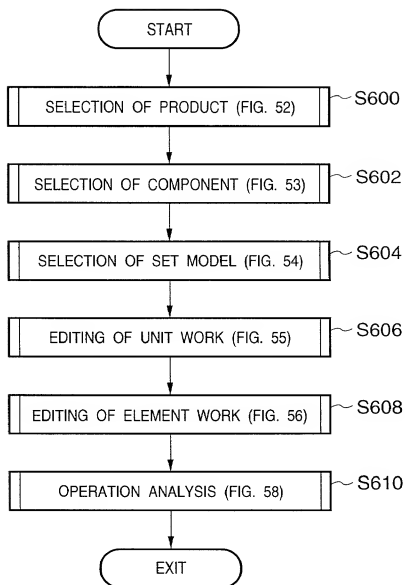
FIG. 51

FIG. 52








| SELECTION OF PRODUCT | | FILE(F) EDIT(E) | | | |
|----------------------|------------------|----------------------|--|--|--|
| | | | | | |
| PRODUCT SYMBOL | NAME | PREVIOUS UPDATE DATE | | | |
| ▶ BJ - 970909 | XXXXX | 1997/09/22 10:17:30 | | | |
| BJ - STAND | | 1997/09/12 15:09:09 | | | |
| BJ - test | TEST 01 Standard | 1997/09/18 10:38:14 | | | |
| BJ250 | 250 TESTS | 1997/09/17 17:58:59 | | | |
| ST01 | STAND PRODUCT | 1997/09/12 16:02:34 | | | |
| STAND01 | | 1997/09/19 15:46:04 | | | |

| | | | | |
|-------------|--------------|----------------------|--------------|-----|
| SET MANHOUR | EXTRACT DATA | CREATE HOST TRANSFER | ANALYZE DATA | END |
|-------------|--------------|----------------------|--------------|-----|

FIG. 53

SELECTION OF COMPONENT

FILE(E) EDIT(E)

PRODUCT SYMBOL : BJ - 4200

NAME : BJ - 4200

| | COMPONENT SYMBOL | NAME | PREVIOUS UPDATE DATE |
|---|------------------|---------------|----------------------|
| ▲ | BK | XXXX | 1997/09/22 11:09:59 |
| | CH | CHECK PROCESS | 1997/09/12 11:09:59 |
| | KO | PACKAGE | 1997/09/18 11:21:07 |

NEXT

DOWNLOAD

UPLOAD

BACK UP

LIST

CANCEL ACCESS FLAG

END

5301

FIG. 54

| SELECTION OF MODEL | | | | |
|--|-------------------|----------|-------|---------------------------|
| <div> <div>FILE(E)</div> <div>EDIT(E)</div> <div>VIEW(V)</div> </div> | | | | |
| <div> <div> <div>FILE(E)</div> <div>EDIT(E)</div> <div>VIEW(V)</div> </div> <div> <div>FILE(E)</div> <div>EDIT(E)</div> <div>VIEW(V)</div> </div> <div> <div>FILE(E)</div> <div>EDIT(E)</div> <div>VIEW(V)</div> </div> </div> | | | | |
| <div> <div>PRODUCT NUMBER : BJ - 970909</div> <div>NAME : 97 - 09 - 09 LOAD</div> </div> | | | | |
| <div> <div>COMPONENT SYMBOL : CH</div> <div>NAME :</div> </div> | | | | |
| SET | MODEL SYMBOL | QUANTITY | NAME | PREVIOUS PUBLICATION DATE |
| ▶ | A250 IIQ | | | |
| | BJC - 4200LX | | | |
| | BJC - 4200 SYSTEM | | | |
| | BJC - 420J | | | |
| | BJC - 420J(BLACK) | | | |
| | BJC - 4300 | | XXXXX | 1997/09/09 10:46:33 |
| | BJC - 430J | | | |
| <div> <div>NEXT</div> <div>REGISTER PUBLICATION</div> <div>LOOK PUBLICATION</div> <div>DISPLAY SAME MODEL</div> <div>END</div> </div> | | | | |

FIG. 55

SELECTION OF MODEL

☐ ☐ ☐

FILE(E) EDIT(E) VIEW(V)

☐ ☐ ☐ ☐ ☐ ☐

PRODUCT SYMBOL : BJ - 970909

NAME : 097 - 09 - 09 LOAD SET MODEL SYMBOL : BJ - 4300

LATEST
REVISION NUMBER

UPDATE
DISPLAY

COMPONENT SYMBOL : ON

NAME : xxxxx

| S | FORMAL MANAGEMENT NO. | REVISION | UNIT WORK NAME | MANHOUR | USE | CS | FREQUENCY |
|--------------------|-----------------------|----------|----------------|---------|-----|----|-----------|
| ▶ N ⁱ 3 | CH-01-01 | 1 | 電気チェック | 0 | 0 | 0 | 1 |
| N ⁱ 4 | CH-01-02(1) | 1 | 電気チェック | 0 | 0 | 0 | 1 |
| N ⁱ 5 | CH-01-02(2) | 1 | 電気チェック | 0 | 0 | 0 | 1 |
| N ⁱ 6 | CH-01-03 | 1 | 電気チェック | 0 | 0 | 0 | 1 |
| N ⁱ 7 | CH-01-04 | 1 | 電気チェック | 0 | 0 | 0 | 1 |
| | | | | | | | |
| N ⁱ 23 | CH-07-02(1) | 1 | フロントカバーu取付 | 0 | 0 | 0 | 1 |
| N ⁱ 24 | CH-07-02(2) | 1 | フロントカバーu取付 | 0 | 0 | 0 | 1 |
| N ⁱ 25 | CH-07-01(3) | 1 | フロントカバーu取付 | 0 | 0 | 0 | 1 |
| N ⁱ 26 | CH-07-01(4) | 1 | フロントカバーu取付 | 0 | 0 | 0 | 1 |

No. FORMAL MANAGEMENT NO.

UNIT WORK NAME

MANHOUR

USE

FREQUENCY

1

2

3

4

5

| ELECTRICAL CHECK | | USE | | FREQUENCY | | 1 | 2 | 3 | 4 | 5 |
|------------------|----------|-----|---|-----------|---|---|---|---|---|---|
| 3 | CH-01-01 | 0 | 0 | 0 | 0 | 1 | | | | |

⊙ CHANGE ⊙ INSERT ⊙ ADD

OK

5501
5507
5506
5502
5503
5504
5505

F I G. 56

| | | | | | | | | | |
|-----------------------|--|----------|--|-----------------------------------|--|-----------------|--|----------------|--|
| XXXXXX | | | | | | | | | |
| | | | | | | | | | |
| FORMAL MANAGEMENT NO. | | PU-03-01 | | UNIT WORK NAME : MOTOR ATTACHMENT | | TOTAL MANHOUR : | | NEXT UNIT WORK | |
| | | | | | | 0 | | | |

| NO. | ELEMENT WORK NAME | REVISION | MANHOUR | USE | CS | SET CONDITION |
|-----|------------------------|----------|---------|-----|----|---------------|
| ▶ 1 | LFモータのケーブルと反対側の軸にタブルギア | 1 | 0 | 0 | | |
| * | | | | | | |

COMMENT 1 : LFモータのケーブルと反対側の軸に

OBJECT : タブルギアを

COMMENT 2 : ギヤ径の小さい方から

VERB : 取付ける 設定

5604 5605 5603 5602 5601

TDEOTO*Th6ES460

FIG. 57

EDITING OF ANALYSIS MATERIAL

FILE(E) EDIT(E) VIEW(V)



PRODUCT GENRE :

ALL

| TYPE | COMMENT 1 | OBJECT | COMMENT 2 | VERB | ANALYSIS SYMBOL | MANHOUR | USE | FREQUENCY | COUNT | SET DATE |
|------|-----------|--------------|--------------|----------------|------------------|---------|-----|-----------|-------|----------------|
| ▶ | I7-キヤプ: | 本体を | 矢印1の様に 入れる | | -50/Gr1/N>6/-3 | 15 | 0 | 1 | 1 | 97/09/09 9:52 |
| | I7-キヤプ: | 本体を | 矢印1の様に 入れる | | -50/E/02/N/-6 | 11 | 0 | 1 | 1 | 97/09/09 9:53 |
| | I7-キヤプ: | 本体を | 矢印1の様に 入れる | | -50/Gr1/N>6/-3 | 15 | 0 | 1 | 1 | 97/09/09 9:55 |
| | | 要素作業01 | 動詞 | | -50/Gr1/N>6/-3 | 15 | 0 | 1 | 1 | 97/09/10 16:34 |
| | I7-キヤプ: | 本体を | 矢印1の様に 入れる | | -50/Gr1/N>6/-3 | 15 | 0 | 1 | 1 | 97/09/10 19:09 |
| | | キリッジ ロック | 塗布する | | Time100/Rate100 | 100 | 100 | 1 | 1 | 97/09/10 19:16 |
| | モータ組立: | アリンタマージ | 入れ、セットする | M211/1/0 | | 50 | 1 | 1 | 1 | 97/09/11 17:00 |
| | | アリンタマージ | 裏面にする | T1221M2311/0/0 | | 12 | 0 | 1 | 1 | 97/09/11 17:34 |
| | 1 | | | | T2221M1211/0/1 | 24 | 0 | 1 | 1 | 97/09/11 17:20 |
| | 2 | | | | T1221M2311/0/0 | 12 | 0 | 1 | 1 | 97/09/11 17:24 |
| | | アリンタマージ | PRが イト 取付る | セットする | | 15 | 0 | 1 | 1 | 97/09/12 11:24 |
| | | dgda1d1as | fgda1d1asfad | | * | 16 | 0 | 1 | 1 | 97/09/12 12:10 |
| | | dsd1s1ds1asf | fgda1d1asfad | | T21121/M1111/0/1 | 13 | 0 | 1 | 1 | 97/09/12 12:10 |
| | | dgda1d1as | fgda1d1asfad | | * | 16 | 0 | 1 | 1 | 97/09/12 13:09 |
| | | アリンタマージ | PRが イト 取付る | セットする | | 15 | 0 | 1 | 1 | 97/09/12 14:00 |
| | | アリンタマージ | PRが イト 取付る | セットする | | 15 | 0 | 1 | 1 | 97/09/12 14:00 |
| | | アリンタマージ | セットする | | Time100/Rate100 | 100 | 100 | 1 | 1 | 97/09/12 14:04 |

FIG. 58











| 5801 | | 5802 | | 5803 | | 5804 | | 5805 | |
|---|-----------------------|-------|----------------|------------------------|-----|---------|--|------|--|
| OPERATION ANALYSIS | | | | | | | | | |
| <div>           </div> | | | | | | | | | |
| 1 SET MAIN BODY TO PREDETERMINED POSITION | | | | | | | | | |
| TOTAL SIMO VALUE : | | 0 | | TOTAL MAN-HOUR VALUE : | | 15 | | SIMO | |
| NEXT ELEMENT WORK | | | | | | | | | |
| NO. | CONTENTS OF OPERATION | WF/OS | SET CONDITION | MAN-HOUR | USE | REMARKS | | | |
| ▲ 1 | XXXXXX | PU | -60/Gr1/N1>6/3 | 15 | 0 | | | | |
| * | | | | | | | | | |

FIG. 59

5901

☐ 1. PU

☐ 2. GET

☐ 3. M

☐ 4. MA

☐ 5. ASY

☐ 6. DSY

☐ 7. R

☐ 8. UMAC

☐ 9. MP

☐ 10. BODY

☐ 11. PU

☐ 12. GET

☐ 13. M

☐ 14. MA

☐ 15. ASY

☐ 16. DSY

☐ 17. R

☐ SIMO

SELECT

5902

CANCEL

FIG. 60

| XXXXXX | | PU | | PICK UP | | MANUAL | |
|--------|-----------------|----|-------|---------|-------|--------|-------|
| 1 : | MOVING DISTANCE | 1 | -10cm | 2 | +10cm | 3 | >50cm |
| 2 : | GRIP TYPE | | Qr-3 | | Qr-2 | | |
| 3 : | PRE-POSITIONING | | NO | | YES | | |
| 4 : | MAIN SIZE | | -10mm | | -6mm | | |
| 5 : | WEIGHT | | <3kg | | >3kg | | |
| 6 : | | | | | | | |

| | | | |
|-----|--------|-----------|---------|
| SET | CANCEL | SET VALUE | FORMULA |
|-----|--------|-----------|---------|

6001 6002 6003

FIG. 61

FORMULA

TURN CHANGE DIRECTION OF BODY MANUAL

FORMULA : 10 * m

VARIABLE

m :

n :

p :

q :

r :

s :

VARIABLE NAME

THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION

VALUE

UNIT

COUNT

SET

CANCEL

SET VALUE

FIG. 62

INQUIRY OF LOG

VARIATION AMOUNT : 10

USE : 0

REASON CODE : 1

CHANGE REASON : SET ▼

OK Clear

6201 6202 6203 6204 6205 6206

FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE

1997 09 22

○ = ○ FROM

⊙ BEFORE ○ ~

SEARCH

| NO. | UNIT WORK NAME | CODE | CHANGE REASON | NEW MANHOUR | (NEW) MANUAL | (NEW) USE | PREVIOUS (PREVIOUS) MANHOUR | PREVIOUS (PREVIOUS) USE | CHANGE DATE |
|------------|------------------|------|---------------|-------------|--------------|-----------|-----------------------------|-------------------------|---------------------|
| ▶ CH-01-01 | ELECTRICAL CHECK | 1 | SET | 10 | 10 | 0 | 0 | 0 | 1997/09/22 14:30.00 |

REASON CODE 1

CHANGE REASON SET

OK

CIR

END

FIG. 64

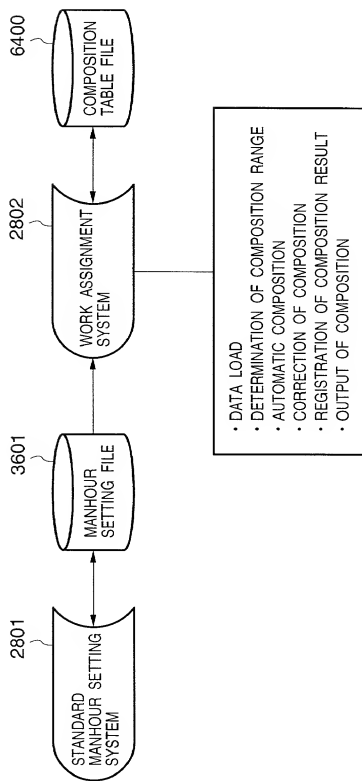


FIG. 65

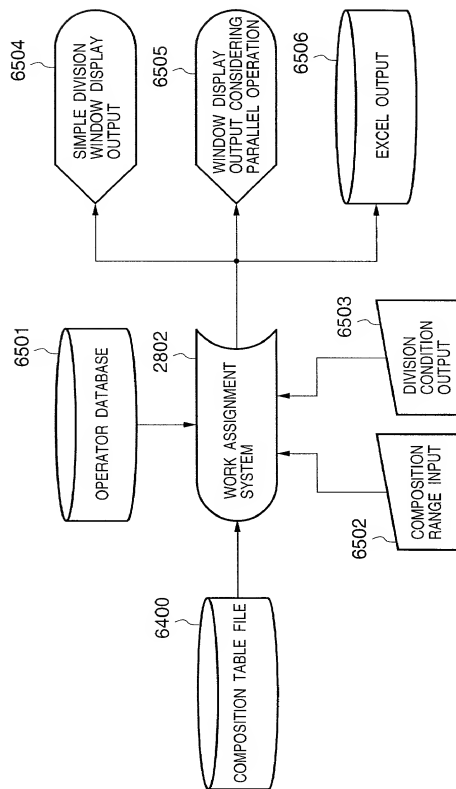


FIG. 66

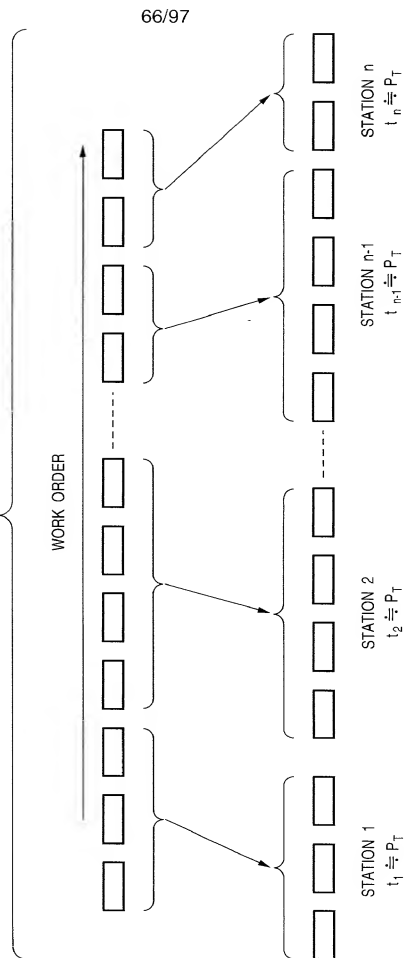


FIG. 67

| | | | | | |
|----------------------------------|--|---|---|---|---|
| | | ▲ | ▼ | ▲ | ▼ |
| FILE(F) EDIT(E) INPUT(I) TOOL(O) | | | | | |

MODEL

GP55

UNIT

| STANDARD NO. | WORK NAME | MAN HOUR |
|--------------|------------------------------|----------|
| 0001 | STICK HANDY CUT TAPE | 134 |
| 0002 | SET LABELS ON MAIN BODY | 550 |
| 0003 | WEIMAN REMOVAL | 270 |
| 0004 | ASSEMBLE OUTER CASE | 365 |
| 0005 | FIT TOP PAD | 268 |
| 0006 | STICK LARGE-SIDE ORDER LABEL | 117 |

⌋

SIMPLE DIVISION
PARALLEL DIVISION

FIG. 68

SIMPLE DIVISION

| | | |
|-----------------|------------------------------|-----|
| | | ▼▲ |
| FILE(F) EDIT(E) | | ◆◆ |
| St 1 | | |
| 0001 | STICK HANDY CUT TAPE | 134 |
| 0002 | SET LABELS ON MAIN BODY | 550 |
| 0003 | WEIMAN REMOVAL | 270 |
| St 2 | | |
| 0004 | ASSEMBLE OUTER CASE | 365 |
| 0005 | FIT TOP PAD | 268 |
| 0006 | STICK LARGE-SIDE ORDER LABEL | 117 |
| ⋮ | | |

FIG. 69

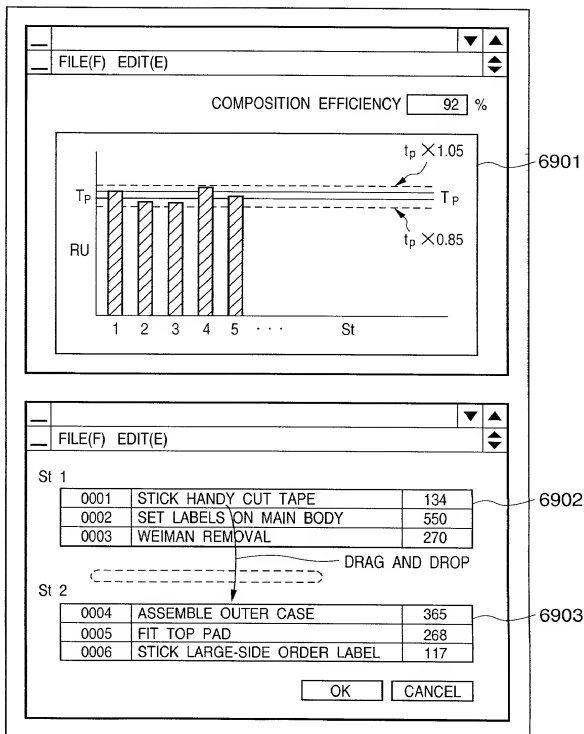
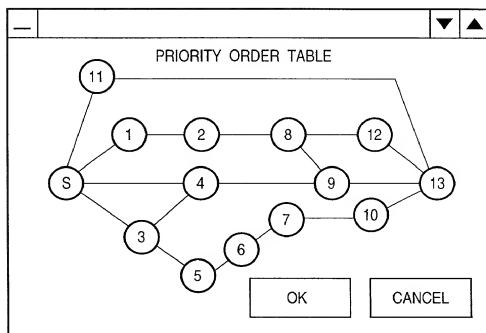


FIG. 70

PARALLEL DIVISION

[illegible]

FIG. 72

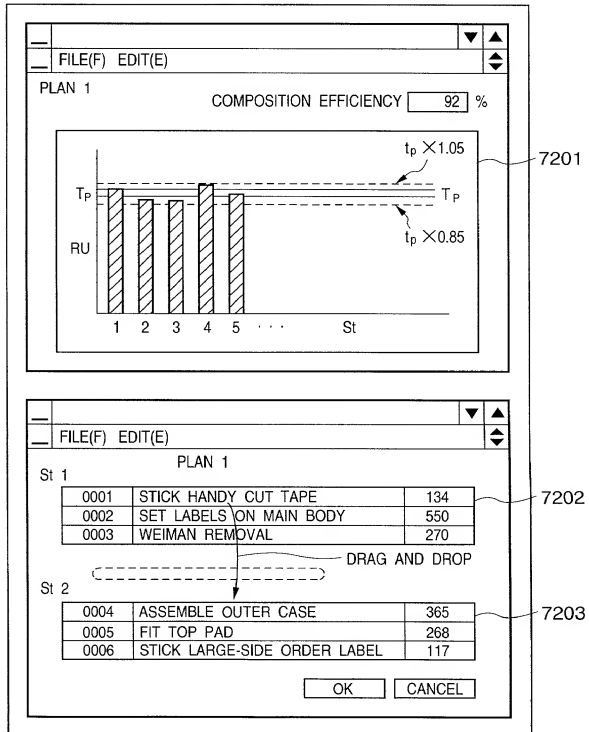


FIG. 73

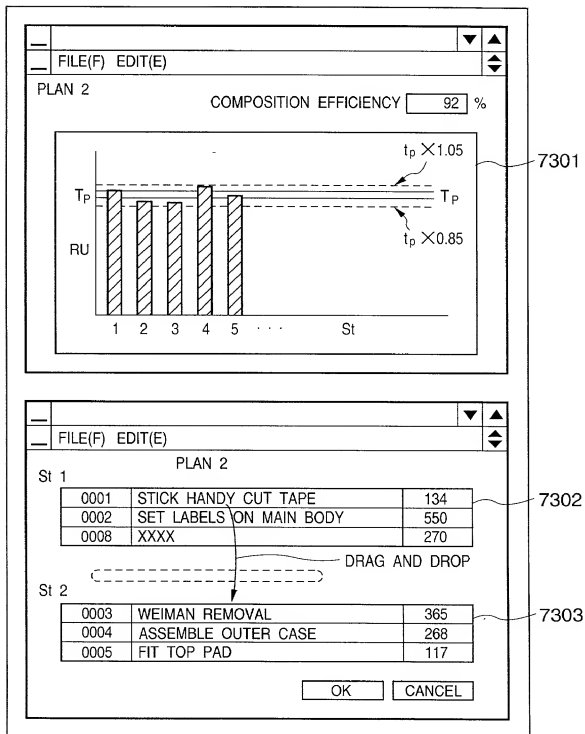


FIG. 74

7403
7404
7405
7406
7407
7409

LOAD OF NEWLY COMPOSED DATA (MANHOUR)

7401

7402

REPRESENTATIVE MODEL

TARGET MODEL

COMPONENT

| COMPONENT SYMBOL | COMPONENT NAME | ORDER |
|------------------|----------------|-------|
| | | |
| | | |

OK

CANCEL

7408

FIG. 75

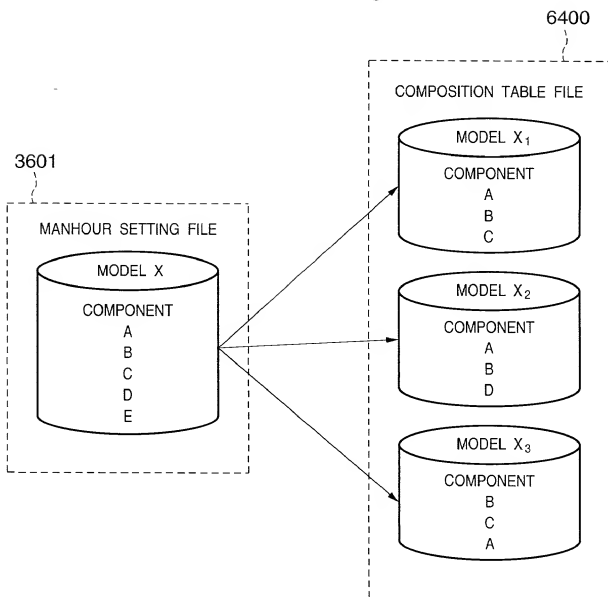


FIG. 76

7601 7602 7603 7604 7606

OPEN FILE

TARGET MODEL NAME REVISION NUMBER SAVE DATE

| | | | |
|--------------|----------------|----|-------------------|
| f12-0010.csv | テストデータ(元) | 1 | 97/09/19 12:00:34 |
| f12-0010.csv | テスト | 0 | 97/09/19 13:27:17 |
| B/C-4300 | 0 | 0 | 97/09/19 14:10:14 |
| B/C-4300 | 0 | 0 | 97/09/19 14:10:32 |
| B/C-4300 | | 1 | 97/09/19 15:41:14 |
| B/C-4300 | B/C-4300Aライン編成 | | 97/09/20 14:16:38 |
| B/C-4300 | B/C-4300Aライン編成 | 03 | 97/10/13 17:54:57 |
| B/C-4300 | B/C-4300Aライン編成 | 00 | 97/09/20 14:06:36 |
| f12-0010.csv | f12-0010Aライン編成 | 05 | 97/09/24 17:11:53 |

SELECT WINDOW

○ COMPOSITION DATA INPUT WINDOW

○ COMPOSITOR DATA CORRECTION WINDOW

OK CANCEL

FIG. 77

7706 7701 7702 7705 7703

INPUT OF COMPOSITION DATA
FILE(E) EDIT(E) TOOL(U)
TARGET MODEL
PER1000

OPTION(Q)
FILE NAME
(COMPOSITION NAME)
REVISION NUMBER 0
COMPOSITION MODE
O WORK O TOOL O PART O NOTE
COMPOSITION PRIORITY
ORDER SCHEME

| G.NO. | WORK NAME | WF | MANUAL | CHIME | MAN/OUR | SECTION | REMARKS |
|-------|--------------|---------|---------|-------------|---------|---------|---------|
| 1 | UNIT NAME | 579 | 0 | G | IN | SET | |
| 1 | WORK | MAN/OUR | MACHINE | PROVISIONAL | MAN/OUR | MAN/OUR | |
| 2 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 3 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 4 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 5 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 6 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 7 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 8 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 9 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 10 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 11 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 12 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 13 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 14 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 15 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 16 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 17 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 18 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 19 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 20 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 21 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 22 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 23 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 24 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 25 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 26 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 27 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 28 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 29 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 30 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 31 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 32 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 33 | WORK NAME | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |
| 34 | STANDARD NO. | WF | MAN/OUR | MAN/OUR | MAN/OUR | MAN/OUR | |

7706 7701 7702 7705 7703

INPUT DATA
THE EXPECTED NUMBER OF PRODUCTS: 680 UNITS
THE NUMBER OF DEFECTIVE PRODUCTS: 0 UNITS
THE NUMBER OF INITIAL PRODUCTS INVESTED INTO TOP OF ASSEMBLY LINE: 556 UNITS
WORKING TIME: 450 MIN
BREAK: 15 MIN
MORNING MEETING TIME: 1 MIN
EXERCISE TIME: 5 MIN
LINE STOP TIME: 0 MIN
OTHERS: 0 MIN
OPERABLE TIME: 429 MIN
EXPECTED COMPOSITION EFFICIENCY: 95 %

7710a 7710b 7710c 7710d 7720a 7720b 7720c 7720d

OUTPUT DATA
STATION (ROUND DOWN): 18 SI
COMPOSITION EFFICIENCY: 100 %
STATION (ROUND UP): 19 SI
COMPOSITION EFFICIENCY: 95 %
THE NUMBER OF STATIONS: 19 SI
COMPOSITION RESULT: 18.9 SI
PITCH TIME (P): 680 RU
EXECUTE COMPOSITION: END

7730 7708 7709

THE NUMBER OF WORKS IN COMPOSITION: 141 TOTAL: 11903 (RU)
TOTAL MAN/OUR IN COMPOSITION: 11903 (RU)
TOTAL MAN/OUR OUTSIDE COMPOSITION: 0 (RU)
TOTAL MAN/OUR OUTSIDE WORKSHOP: 0 (RU)

FIG. 78

09753941 010301
T06010 T+65260

INSERTION OF UNIT WORK

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

UNIT WORK NAME :

7801

PROVISIONAL MANHOUR : (RU)

7802

REMARKS :

OK

CANCEL

FIG. 79

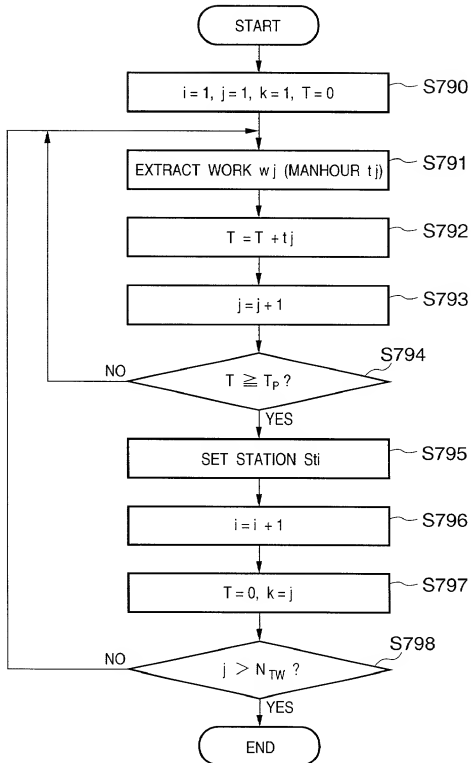


FIG. 80

FILE(E) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1

S11

| WORK NAME | PROV-SIGNAL | WF | MAN-CHINE | UAL |
|------------|-------------|----|-----------|-----|
| UNIT NAME1 | 59 | 0 | 9000 | |
| UNIT NAME2 | 54 | 0 | 9000 | |
| UNIT NAME3 | 10 | 0 | 9000 | |
| UNIT NAME4 | 50 | 0 | 9000 | |

OPERATOR 2

S12

| WORK NAME | PROV-SIGNAL | WF | MAN-CHINE | UAL |
|------------|-------------|----|-----------|-----|
| UNIT NAME1 | 63 | 0 | 9000 | |
| UNIT NAME2 | 30 | 0 | 9000 | |
| UNIT NAME3 | 155 | 0 | 9000 | |
| UNIT NAME4 | 35 | 0 | 9000 | |

OPERATOR 3

S13

| WORK NAME | PROV-SIGNAL | WF | MAN-CHINE | UAL |
|------------|-------------|----|-----------|-----|
| UNIT NAME1 | 1441 | 0 | 9000 | |
| UNIT NAME2 | 161 | 0 | 9000 | |
| UNIT NAME3 | 292 | 0 | 9000 | |
| UNIT NAME4 | 105 | 0 | 9000 | |

OPERATOR 4

S14

| WORK NAME | PROV-SIGNAL | WF | MAN-CHINE | UAL |
|------------|-------------|----|-----------|-----|
| UNIT NAME1 | 33 | 0 | 9000 | |
| UNIT NAME2 | 72 | 0 | 9000 | |
| UNIT NAME3 | 35 | 0 | 9000 | |
| UNIT NAME4 | 55 | 0 | 9000 | |

OPERATOR 5

S15

| WORK NAME | PROV-SIGNAL | WF | MAN-CHINE | UAL |
|------------|-------------|----|-----------|-----|
| UNIT NAME1 | 250 | 0 | 9000 | |
| UNIT NAME2 | 0 | 0 | 9000 | |
| UNIT NAME3 | 50 | 0 | 9000 | |
| UNIT NAME4 | 55 | 0 | 9000 | |

TOTAL 683 (RU)

PF 105.0%

TOTAL 609 (RU)

PF 92.3%

TOTAL 566 (RU)

PF 86.8%

TOTAL 596 (RU)

PF 90.3%

TOTAL 565 (RU)

PF 85.8%

8004 8005 8006

G STANDARD NO. WORK NAME UNIT NAME1

1 0

COMPOSITION MODE: PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY 94.92 %

NET COMPOSITION EFFICIENCY %

8001

8002

8003

8009

8008

8004

8005

8006

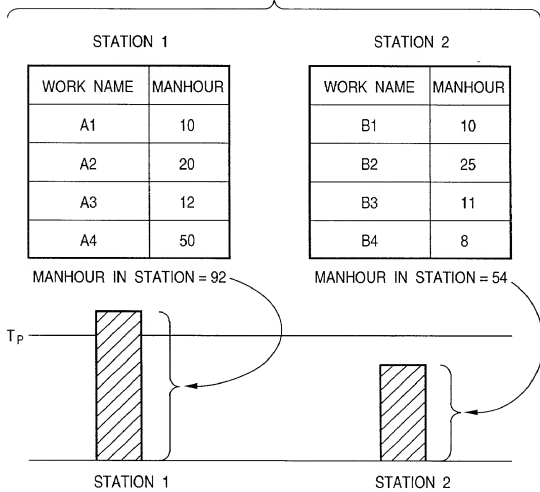
FIG. 81

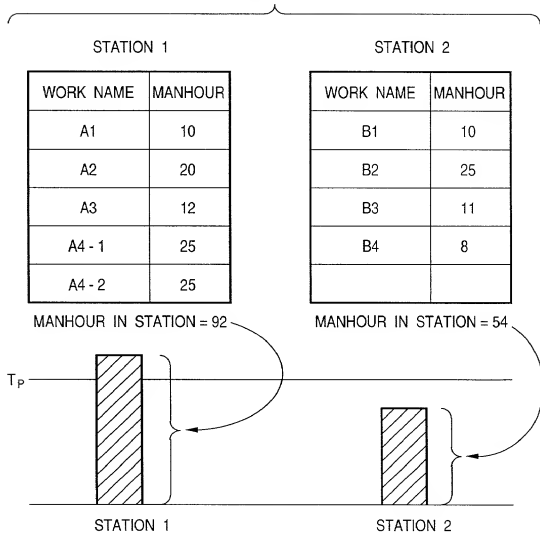
FIG. 82

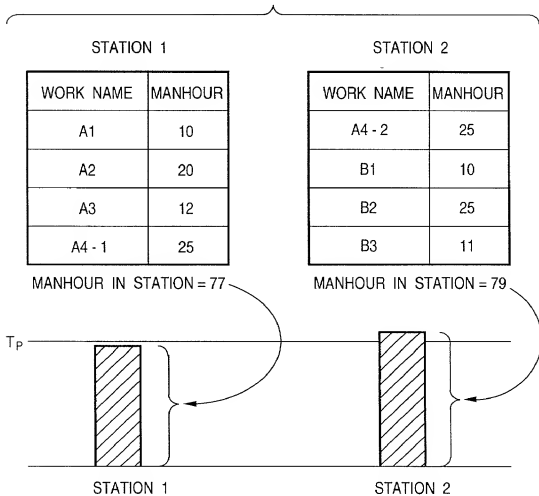
FIG. 83

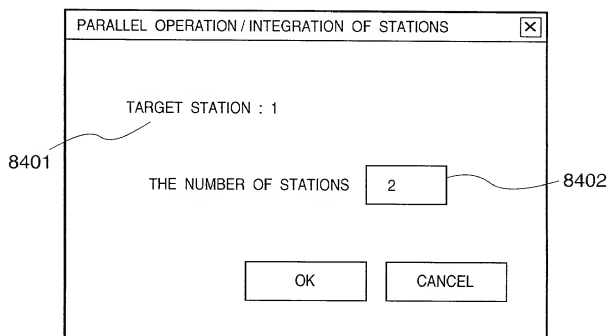
FIG. 84

FIG. 85

FILE(E) EDIT(E) VIEW(D) TOOL(T)

OPERATOR 1 OPERATOR 2 OPERATOR 3 OPERATOR 4 OPERATOR 5

S1 S2 S3 S4 S5

| UNIT WORK NAME | PROV. MAN-CHINE UAL | WF SOCIAL MAN-CHINE UAL | PROV. MAN-CHINE UAL | WF SOCIAL MAN-CHINE UAL | PROV. MAN-CHINE UAL | WF SOCIAL MAN-CHINE UAL | PROV. MAN-CHINE UAL | WF SOCIAL MAN-CHINE UAL | PROV. MAN-CHINE UAL | WF SOCIAL MAN-CHINE UAL |
|----------------|---------------------|-------------------------|---------------------|-------------------------|---------------------|-------------------------|---------------------|-------------------------|---------------------|-------------------------|
| START | 0 | 0 | No | | | | | | | |
| NAME 1 | 34 | 10 | No 01 | | | | | | | |
| UNIT WORK 255 | 46 | No 02 | | | | | | | | |
| NAME 2 | | | | | | | | | | |
| UNIT WORK 92 | 26 | No 06 | | | | | | | | |
| NAME 3 | | | | | | | | | | |
| UNIT WORK 52 | 0 | No 07 | | | | | | | | |
| NAME 4 | | | | | | | | | | |
| UNIT WORK 52 | 0 | No 06 | | | | | | | | |
| NAME 5 | | | | | | | | | | |
| UNIT WORK 0 | 36 | No 09 | | | | | | | | |
| NAME 6 | | | | | | | | | | |
| UNIT WORK 54 | 0 | No 03 | | | | | | | | |
| NAME 7 | | | | | | | | | | |
| UNIT WORK 97 | 20 | No 12 | | | | | | | | |
| NAME 8 | | | | | | | | | | |
| UNIT WORK 88 | 0 | No 14 | | | | | | | | |
| NAME 9 | | | | | | | | | | |
| UNIT WORK 46 | 18 | No 15 | | | | | | | | |
| NAME 10 | | | | | | | | | | |
| UNIT WORK 546 | 15 | No 16 | | | | | | | | |
| NAME 11 | | | | | | | | | | |
| UNIT WORK 58 | 20 | No 17 | | | | | | | | |
| NAME 12 | | | | | | | | | | |
| UNIT WORK 13 | | No 18 | | | | | | | | |
| NAME 13 | | | | | | | | | | |
| UNIT WORK 301 | 131 | No 19 | | | | | | | | |
| NAME 14 | | | | | | | | | | |
| UNIT WORK 84 | 26 | No 20 | | | | | | | | |
| NAME 15 | | | | | | | | | | |
| UNIT WORK 120 | 20 | No 21 | | | | | | | | |
| NAME 16 | | | | | | | | | | |
| UNIT WORK 310 | 66 | No 22 | | | | | | | | |
| NAME 17 | | | | | | | | | | |
| UNIT WORK 146 | 71 | No 23 | | | | | | | | |
| NAME 18 | | | | | | | | | | |
| UNIT WORK 106 | 26 | No 24 | | | | | | | | |
| NAME 19 | | | | | | | | | | |
| UNIT WORK 51 | 10 | No 25 | | | | | | | | |
| NAME 20 | | | | | | | | | | |
| UNIT WORK 0 | 0 | No X | | | | | | | | |
| NAME 21 | | | | | | | | | | |
| UNIT WORK 84 | 26 | No 19 | | | | | | | | |
| NAME 22 | | | | | | | | | | |
| UNIT WORK 106 | 26 | No 23 | | | | | | | | |
| NAME 23 | | | | | | | | | | |
| UNIT WORK 81 | 0 | No 24 | | | | | | | | |
| NAME 24 | | | | | | | | | | |
| UNIT WORK 51 | 10 | No 25 | | | | | | | | |
| NAME 25 | | | | | | | | | | |
| UNIT WORK 0 | 0 | No X | | | | | | | | |
| NAME 26 | | | | | | | | | | |

TOTAL 585 (RU) PF 83.5%

TOTAL 1548 (RU) xxxxxxxx PF 23.5%

PARALLEL STATIONS

900 720 540 360 180 0

1 2 3 4 5

G STANDARD NO. WORK NAME

WF MEANS MA

PROVISIONAL CHINE MAN-CHINE UAL

REMARKS

COMPOSITION EFFICIENCY 116 %

NET COMPOSITION EFFICIENCY %

COMPOSITION MODE: PRIORITY ORDER SCHEME

PF 95.2%

PF 96.7%

PF 73.6%

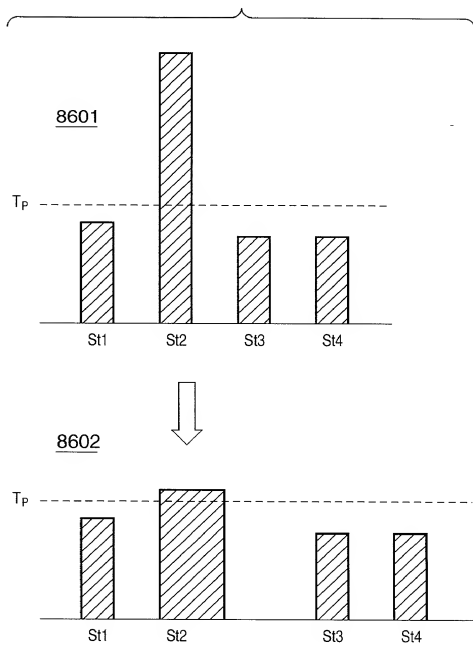
FIG. 86

FIG. 87

A screenshot of a 'USER REGISTRATION' dialog box. The dialog has a title bar with a close button. It contains five input fields with labels to their left: 'NAME CODE', 'NAME', 'POSITION', 'PASSWORD', and 'AUTHORITY'. The 'NAME' field is split into two boxes containing '田中' and '一郎'. The 'POSITION' field is a dropdown menu showing 'kumitate'. At the bottom are 'OK' and 'CANCEL' buttons. Five callout lines with numbers point to specific parts: 8701 points to the 'NAME CODE' value '12345'; 8702 points to the first part of the 'NAME' field '田中'; 8703 points to the second part of the 'NAME' field '一郎'; 8704 points to the 'PASSWORD' value '12345'; and 8705 points to the 'AUTHORITY' field.

USER REGISTRATION

NAME CODE : 12345 8701

NAME : 田中 一郎 8702 8703

POSITION : kumitate ▼ 8703

PASSWORD : 12345 8704

AUTHORITY : 8705

OK CANCEL

FIG. 88

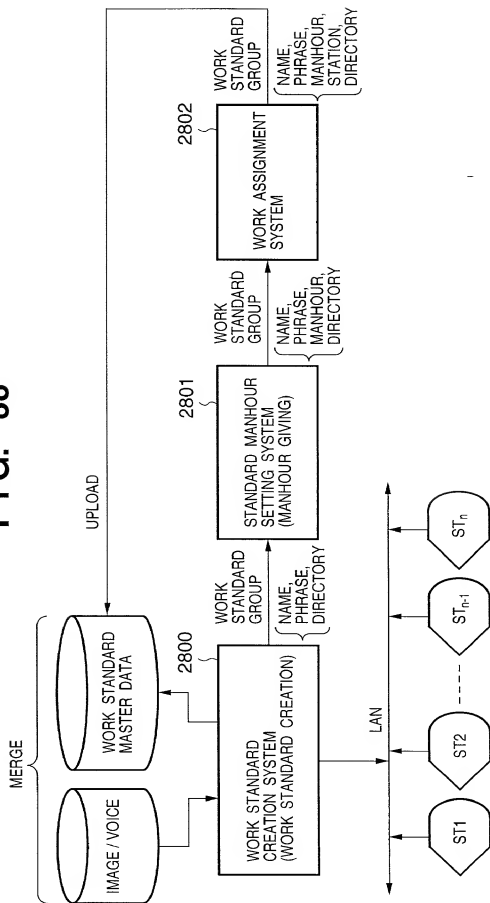
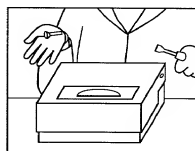


FIG. 89

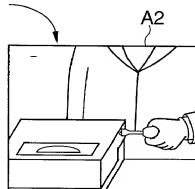
| DIRECTORY NAME | IMAGE DATA | OPERATION (VERB) | PARAMETER 1 | PARAMETER 2 | PARAMETER 3 |
|----------------|------------|------------------|------------------|------------------------|---------------|
| xxxxx1 | SCREW | SCREW | SCREW CLOCKWISE | DISTANCE MOVEMENT 10mm | TORQUE 10Kg.M |
| xxxxxx2 | SCREW | SCREW | SCREW CLOCKWISE | DISTANCE MOVEMENT 20mm | TORQUE 20Kg.M |
| xxxxxx3 | SCREW | SCREW | SCREW CLOCKWISE | DISTANCE MOVEMENT 20mm | TORQUE 30Kg.M |
| ... | ... | ... | ... | ... | ... |
| yyyyyy1 | ROTATE | ROTATE | CLOCKWISE | DISTANCE MOVEMENT 20mm | |
| yyyyyy2 | ROTATE | ROTATE | COUNTERCLOCKWISE | DISTANCE MOVEMENT 20mm | |
| ... | ... | ... | ... | ... | ... |
| zzzzzz1 | OPEN | OPEN | OPEN UPWARD | DISTANCE MOVEMENT 30mm | WEIGHT 100g |
| zzzzzz2 | OPEN | OPEN | OPEN DOWNWARD | DISTANCE MOVEMENT 40mm | WEIGHT 200g |
| ... | ... | ... | ... | ... | ... |

FIG. 90

1. SCREW A



A1

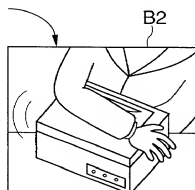


A2

2. ROTATE MAIN BODY



B1

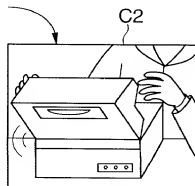


B2

3. OPEN COVER



C1



C2

FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ - 970909

COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

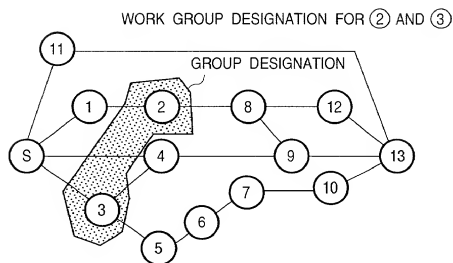
FIG. 92

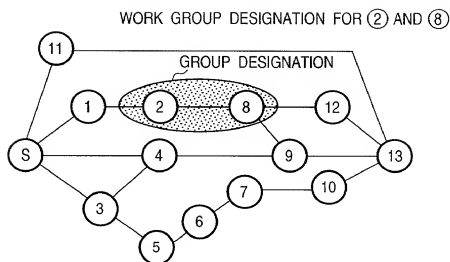
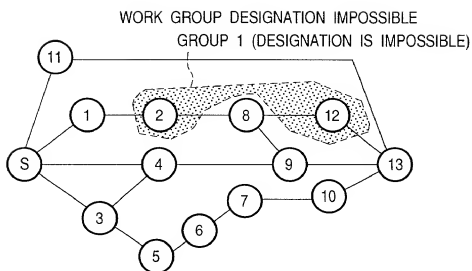
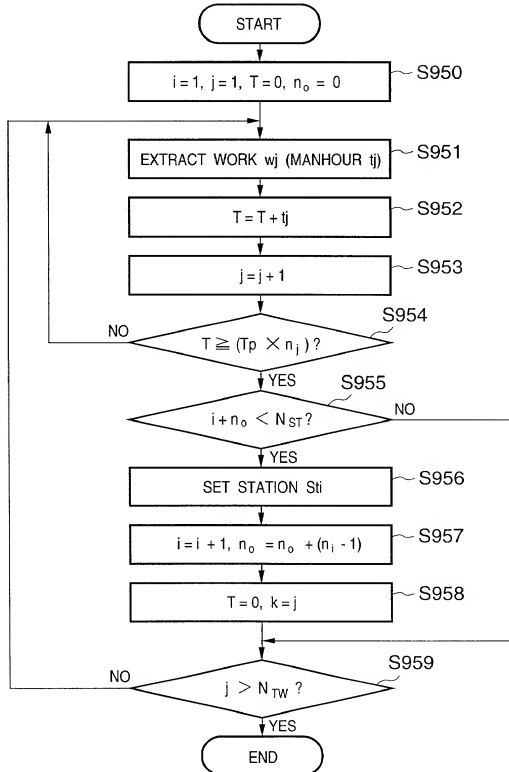
FIG. 93

FIG. 94

95/97

FIG. 95

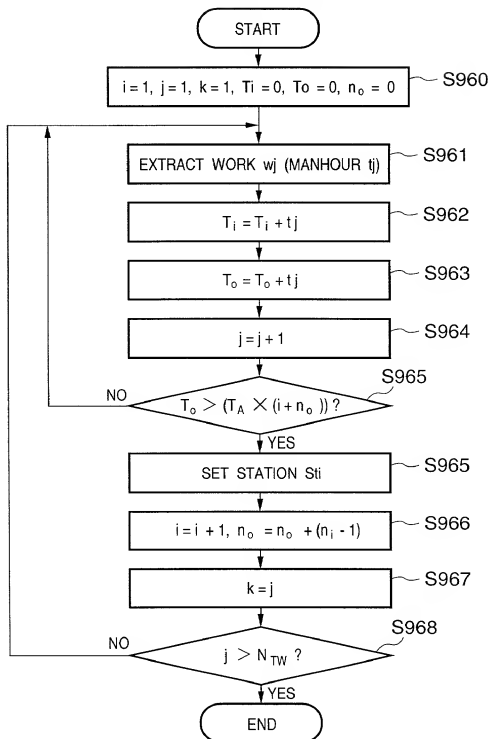


N_{ST} : THE NUMBER OF STATIONS
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

09753941-010301

96/97

FIG. 96

 N_{ST} : THE NUMBER OF STATIONS T_i : i STATION MANHOUR T_A : STATION MANHOUR AVERAGE VALUE $T_A = WF / N_{ST}$ T_o : TOTAL ACCUMULATED MANHOUR n_i : i STATION PARALLEL NUMBER n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

09752944.010301

FIG. 97

FILE(E) EDIT(E) VIEW(V) TOOL(T)
OPERATOR 1 OPERATOR 2 OPERATOR 3 OPERATOR 4 OPERATOR 5 OPERATOR 6

OPERATOR 1

| WORK NAME | PROV. MANHOUR | WF SOCIAL | MA CHINE | MAN-UAL |
|---------------|---------------|-----------|----------|---------|
| START | 0 | 0 | No | |
| UNIT WORK 34 | 10 | No 01 | | |
| NAME 1 | | | | |
| UNIT WORK 255 | 46 | No 02 | | |
| NAME 2 | | | | |
| UNIT WORK 92 | 26 | No 06 | | |
| NAME 3 | | | | |
| UNIT WORK 52 | 0 | No 07 | | |
| NAME 4 | | | | |
| UNIT WORK 52 | 0 | No 08 | | |
| NAME 5 | | | | |
| UNIT WORK 0 | 36 | No 09 | | |
| NAME 6 | | | | |

OPERATOR 2

| WORK NAME | PROV. MANHOUR | WF SOCIAL | MA CHINE | MAN-UAL |
|---------------|---------------|-----------|----------|---------|
| UNIT WORK 156 | 0 | No 03 | | |
| NAME 3 | | | | |
| UNIT WORK 34 | 0 | No 04 | | |
| NAME 4 | | | | |
| UNIT WORK 138 | 23 | No 06 | | |
| NAME 5 | | | | |
| UNIT WORK 71 | 48 | No 10 | | |
| NAME 10 | | | | |
| UNIT WORK 138 | 30 | No 11 | | |
| NAME 11 | | | | |
| UNIT WORK 97 | 20 | No 12 | | |
| NAME 12 | | | | |
| UNIT WORK 88 | 0 | No 14 | | |
| NAME 13 | | | | |
| UNIT WORK 46 | 18 | No 15 | | |
| NAME 14 | | | | |
| UNIT WORK 546 | 15 | No 16 | | |
| NAME 15 | | | | |
| UNIT WORK 58 | 20 | No 17 | | |
| NAME 16 | | | | |

OPERATOR 3

| WORK NAME | PROV. MANHOUR | WF SOCIAL | MA CHINE | MAN-UAL |
|---------------|---------------|-----------|----------|---------|
| UNIT WORK 30 | 40 | No 13 | | |
| NAME 13 | | | | |
| UNIT WORK 303 | 131 | No 18 | | |
| NAME 18 | | | | |

OPERATOR 4

| WORK NAME | PROV. MANHOUR | WF SOCIAL | MA CHINE | MAN-UAL |
|---------------|---------------|-----------|----------|---------|
| UNIT WORK 84 | 26 | No 19 | | |
| NAME 19 | | | | |
| UNIT WORK 20 | 20 | No 20 | | |
| NAME 20 | | | | |
| UNIT WORK 310 | 66 | No 21 | | |
| NAME 21 | | | | |

OPERATOR 5

| WORK NAME | PROV. MANHOUR | WF SOCIAL | MA CHINE | MAN-UAL |
|---------------|---------------|-----------|----------|---------|
| UNIT WORK 146 | 71 | No 22 | | |
| NAME 22 | | | | |
| UNIT WORK 09 | 26 | No 23 | | |
| NAME 23 | | | | |
| UNIT WORK 61 | 0 | No 24 | | |
| NAME 24 | | | | |
| UNIT WORK 51 | 10 | No 25 | | |
| NAME 25 | | | | |
| END | 0 | No X | | |

OPERATOR 6

| WORK NAME | PROV. MANHOUR | WF SOCIAL | MA CHINE | MAN-UAL |
|---------------|---------------|-----------|----------|---------|
| UNIT WORK 146 | 71 | No 22 | | |
| NAME 22 | | | | |
| UNIT WORK 09 | 26 | No 23 | | |
| NAME 23 | | | | |
| UNIT WORK 61 | 0 | No 24 | | |
| NAME 24 | | | | |
| UNIT WORK 51 | 10 | No 25 | | |
| NAME 25 | | | | |
| END | 0 | No X | | |

PARALLEL STATIONS
 TOTAL 665 (RU) PF 83.6% PARALLEL STATIONS PF 117.3%

PARALLEL STATIONS
 TOTAL 1548 (RU) xxxxxxxx PF 95.2%

PARALLEL STATIONS
 TOTAL 572 (RU) PF 96.7%

PARALLEL STATIONS
 TOTAL 6238 (RU) PF 95.2%

PARALLEL STATIONS
 TOTAL 486 (RU) PF 73.6%

COMPOSITION
 EFFICIENCY 96.43 %
 NET COMPOSITION %

COMPOSITION
 EFFICIENCY 96.43 %
 NET COMPOSITION %

COMPOSITION
 EFFICIENCY 96.43 %
 NET COMPOSITION %

COMPOSITION
 EFFICIENCY 96.43 %
 NET COMPOSITION %